

Work Order ID 72220

Wednesday, July 20, 2011 8:03:50 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 7/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/07/20

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3929

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.00

11/07/206

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

11/07/206

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11 07 21 (6)

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M11464911.07.25
TAB 11/07/25 (6)

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.07.25 (6)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M 11 07 25 6

170

Identify as per dwg & Stock Location: WAS 0.00

0.00



Packaging

Memo

0.00

Packaging

11.07.25 6

180

QC21- Final Inspection - Work Order Release 0.00

0.00



QC

Memo

0.00

Quality Control

nh/25 6
11-07-25 6

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, July 20, 2011 8:03:48 AM

Page 1

Work Order ID: 72220

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 7/20/2011

Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

79.0000

0.45

2.842105



304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

79

117494

79

D3907-1

Manufactured

No

130

Each

53.0000

2

12



Bushing

Location

Loc Qty

Loc Code

WA

49

70673

40

71533

9

WA005

4

65920

4

3.04 11/07/20

PMB 11/07/23

12

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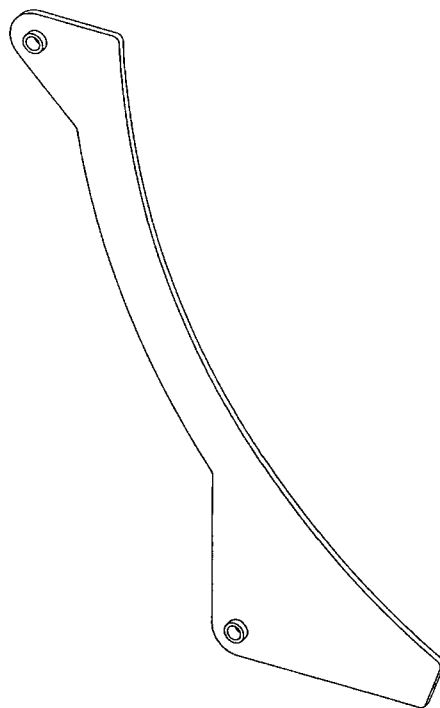
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

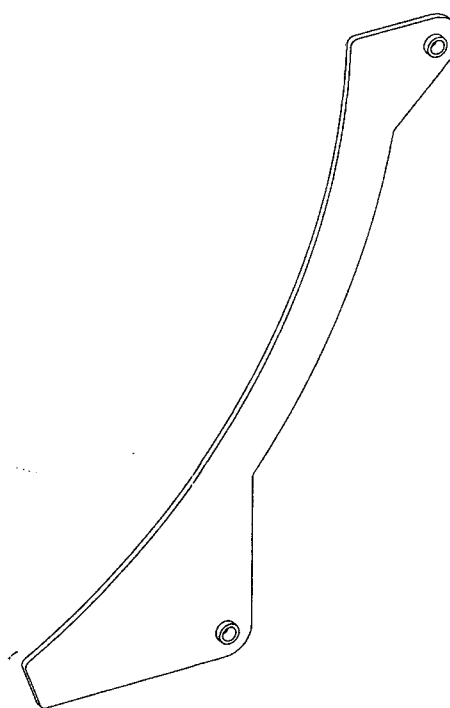
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

CL 11/07/20
W10:72220

RELEASED
3/6/4/2 MJD

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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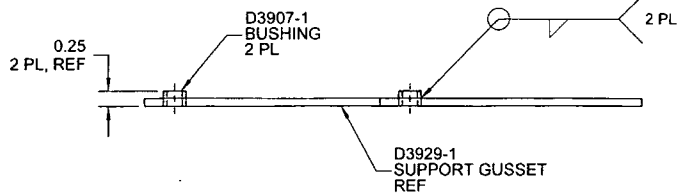
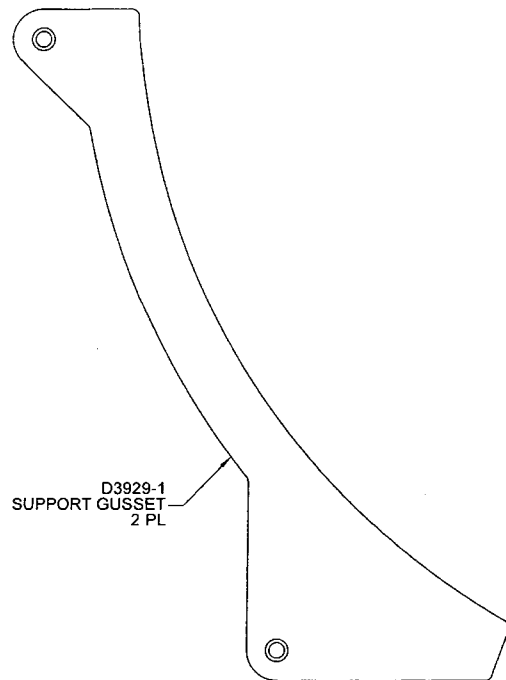
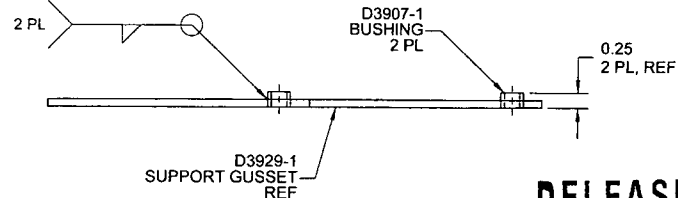
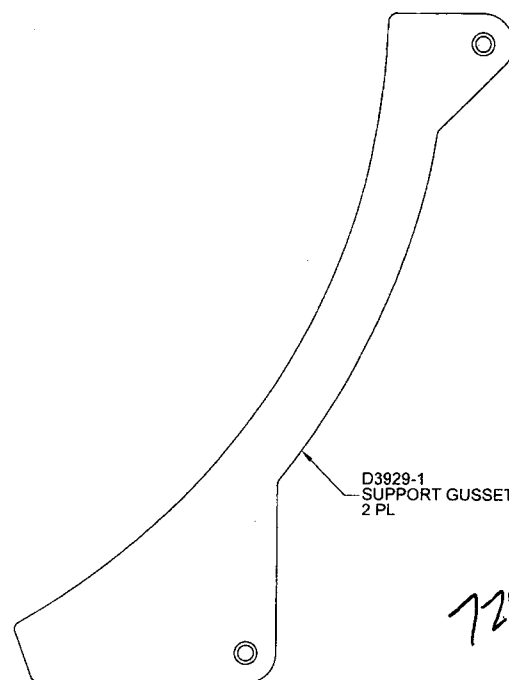
1

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B

A

**D3929-041 GUSSET ASSEMBLY****D3929-042 GUSSET ASSEMBLY**

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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